

Date: Tuesday, 5/23/2006 8:36:28 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number : 27207	
Estimate Number : 10836	
P.O. Number : N/A	Part Number : D29391
This Issue : 5/23/2006 S.O. No. : N/A	Drawing Number : D2939 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 25638	Material : N/A
Written By : <i>See comment below</i>	Due Date : 6/30/2006 Qty: 8 Um: Each
Checked & Approved By : <i>06.05.23</i>	
Comment : Est: 800.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: *325342*

SD 06.07.11

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
5-Deburr

JL/SD 06.07.12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

Ep 06.07.12 x 8

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

3/4 SD 06.07.12

H:\forms\Quality Assurance\approved forms\NCRWO rev C

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/07/28

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:36:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 27207

Part Number: D29391

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

FM 06/07/24

8

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/25

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25

⑤

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AP 06/07/27

⑧

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: */*

AP 06/07/27

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/07/28

Job Completion



KJ 06.07.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action · Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27207
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.126	.124	.126		
B	0.100	0.140		.125	.127	.125	.127		
C	0.100	0.140		.124	.121	.122	.122		
D	0.210	0.230		.225	.223	.223	.223		
E	1.245	1.255		1.256	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505							
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.122	.120	.120	.120		
O	0.540	0.560		.547	.547	.547	.548		
P	0.490	0.510		.500	.498	.499	.501		
Q	3.715	3.725		3.720	3.720	3.726	3.720		
R	2.720	2.760		2.740	2.740	2.746	2.740		
S	0.240	0.270		.255	.252	.252	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.250	1.270		1.258	1.2575	1.258	1.257		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD	Audited by: JML
Date: 06.07.12 / 06/07/24	Date: 06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

4HL 916 -.005
911 -.005

DART AEROSPACE LTD	Work Order: 27207
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. B	Page 1 of 1

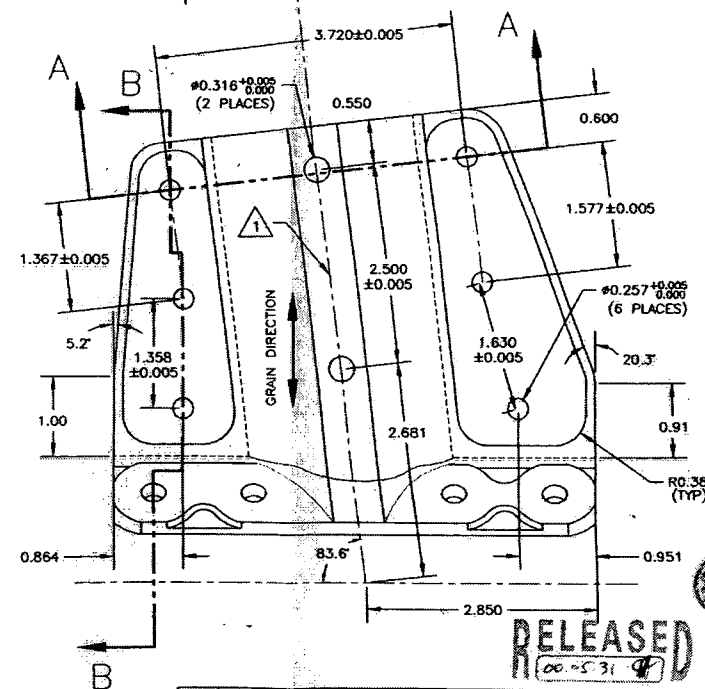
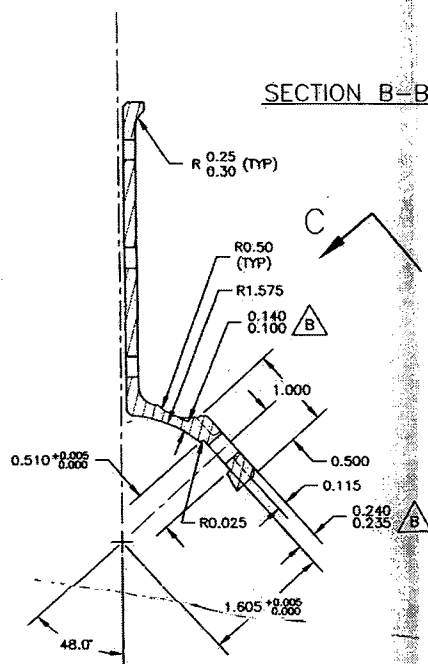
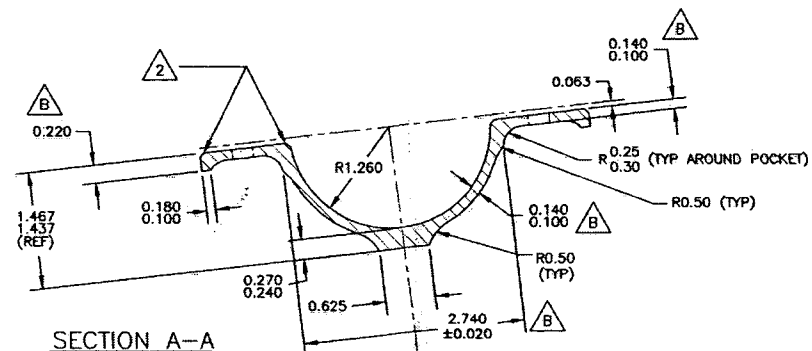
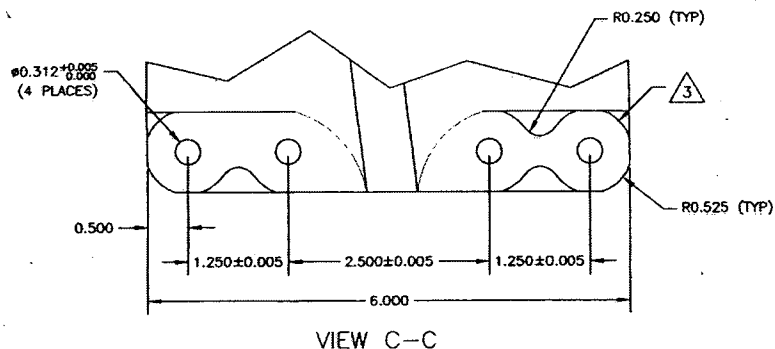
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.126	.126	.125		
B	0.100	0.140		.127	.124	.125	.125		
C	0.100	0.140		.122	.121	.121	.122		
D	0.210	0.230		.224	.224	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.499	2.500		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.500	2.499	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.121	.121	.120	.119		
O	0.540	0.560		.550	.550	.549	.550		
P	0.490	0.510		.500	.500	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.252	.250	.250	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.628	1.630	1.629	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.250	1.270		1.257	1.258	1.257	1.257		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: SA / J.L	Audited by: ml
Date: 06.07.12 / 06/07/13	Date: 06/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27207

RELEASED
 00-531

B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	00.05.29	TITLE SADDLE INSIDE
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		REV. B SHEET 1 OF 1 SCALE 2:3